

SHIP REPAIR  
29/06

Work Order ID 83649

April-23-12 10:08:22 AM

\*83649\*

Page 1

Item ID: D350-591-133

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Maintenance Step

Start Date: 23/04/2012 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/04/23 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2946

Rev B

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

8.7/06/29

ML5 12/06/29

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

\*\*Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.\*\*

\$ 0

Ac

12-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**\*83649\***

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Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 23/04/2012    **Start Qty:** 5.00    **\*5\***

**Cust Item ID:**

**Required Date:** 07/05/2012      **Req'd Qty:** 5.00      **\*5\***

**Customer:**

**Reference:**

**Approvals:**    **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start** **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NR2\***

[illegible]

W/O:		WORK ORDER CHANGES					
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**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

**\*180\***

Large Fab

Large Fab

Memo

0.00

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: 12085450AK12.06.27Ac  
12.06.28

190

**\*190\***

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8.7.10.12.22

200

**\*200\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8.7.10.12.22(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*210*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*220*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11h25 OVEN TEMPERATURE: 320°F FINISH TIME: 11h55								
230	Wing Walk as per dwg QSI005 4.4 Batch 121613	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

5 NG 12-6-28

5 X (DP) 12/06/28

5 φ 12-6-28

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Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Memo

0.00

Quality Control

5x *f* *HL nlocel28*

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

5x *SP*  
*12-6-28*

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

*S r/ackg**(S)*

W/O:		WORK ORDER CHANGES					
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Page 7

April-23-12 10:08:22 AM

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Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-133								
	Location: <u>S9A</u>								
	PPP Rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

*12/06/29**MLW 12/06/29**MF 12-06-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

April-23-12 10:08:28 AM

Page 1

Work Order ID: 83649

\*83649\*

Parent Item: D350-591-133

\*D350-591-133\*

Parent Item Name: Aft Maintenance Step

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:B05.10.14Modified step 10KJ/EC  
IPP Rev:B06.07.19D2946 @ rev.b EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			110	Each	129.7300	0.52	2.6			

\*D2622-120C\*

Step Extrusion

\*\*

B83894

x5 A2

12.06.26

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	104	
81507	104	
WA013	9.36	
75781	2	
77612	7.36	

D2734

Manufactured No

130 Each

53.0000

2

10

\*D2734\*

Step End Plate

\*\*

12.06.26

Location	Loc Qty	Loc Code
WA	53	
76985	25	
80682	28	
B84563		

9

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-23-12 10:08:28 AM

Page 2

Work Order ID: 83649

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

\*83649\*

\*D350-591-133\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 5.00

Required Qty: 5.00

D2944

Manufactured No

130

Each

22 0000

2

10

\*D2944\*

Step Mounting Plate

\*\*

12.06.26

## Location

## Loc Qty

## Loc Code

WA018

22

73427

4

82109

18

AN4-11A

Purchased

No

250

Each

244.0000

\*\*

10  
20

\*AN4-11A\*

Bolt

6x121708 SP

## Location

## Loc Qty

## Loc Code

ST356

244

118706

94

120731

100

121243

50

AN4-14A

Purchased

No

250

Each

407.0000

\*\*

8 40

\*AN4-14A\*

Bolt

SP 12-6-28

## Location

## Loc Qty

## Loc Code

357

100

121349

100

ST357

307

120187

13

120769

1

121068

17

121162

76

121243

100

121444

100

40x

April-23-12 10:08:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-23-12 10:08:28 AM

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Parent Item Name: Aft Maintenance Step

\*83649\*

\*D350-591-133\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 5.00

Required Qty: 5.00

AN4-16A  
\*AN4-16A\*  
Bolt

Purchased

No

250

Each

187.0000

40

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST358

187

120498

14

121060

98

121444

75

28x

12x

AN4-7A  
\*AN4-7A\*  
Bolt

Purchased

No

250

Each

156.0000

10

\*\*

SP

## Location

## Loc Qty

## Loc Code

ST356

156

117514

56

120770

100

10x

AN960JD416  
\*AN960JD416\*  
Washer

NAS1149D0463J

Purchased

No

250

Each

10.0000

\*\*

70

m/12/19/12 SP

## Location

## Loc Qty

## Loc Code

ST351

10

116289

10

D2230-1  
\*D2230-1\*  
Lug

Manufactured

No

250

Each

30.0000

\*\*

20

B83273 SP

12-6-28

## Location

## Loc Qty

## Loc Code

ST

4

78596

4

ST480

26

67826

6

70974

3

80008

17

April-23-12 10:08:28 AM

Shop Packet Print

Page 3

**Dart Aerospace Ltd**

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Parent Item Name: Aft Maintenance Step

\*83649\*

\*D350-591-133\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 5.00

Required Qty: 5.00

D2230-3

Manufactured No

250

Each

147.0000

\*D2230-3\*

Lug

\*\*

20

B.84/33 SP

Location

Loc Qty

Loc Code

ST480

147

53881

4

70973

1

81558

142

D2732

Manufactured No

250

f

86.4153

2

10

\*D2732\*

Rubber Extrusion

\*\*

SP

Location

Loc Qty

Loc Code

ST410

86.415299

70987

86.415299

70987

D2856-400

Manufactured No

250

f

353.5345

1.26

6.3

\*D2856-400\*

Abrasion Strip

\*\*

SP 12-6-28

Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

137.5345

63735

0.6696

68076

0.3149

71164

8.46

79551

128.09

6.3

April-23-12 10:08:29 AM

Shop Packet Print

Page 4

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Parent Item Name: Aft Maintenance Step

\*83649\*

\*D350-591-133\*

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 5.00

Required Qty: 5.00

D2945

Manufactured No

250

Each

12.0000

1 5

\*\*

\*D2945\*

Step Mounting Plate

Location

Loc Qty

Loc Code

ST022

12

79056

12

Purchased

No

250

Each

6,110.000

14 70

\*\*

MS21042L4

\*MS21042L4\*

Nut

Location

Loc Qty

Loc Code

ST300

6110

116188

5

119017

4

119075

1101

121011

2000

121444

3000

70X

April-23-12 10:08:29 AM

Shop Packet Print

Page 5

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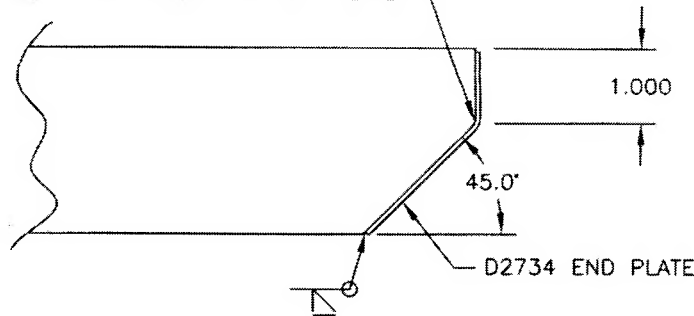


# **D2946 STEP ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

\*cut per drawing

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE



**TYPICAL STEP END DETAIL**  
NOT TO SCALE

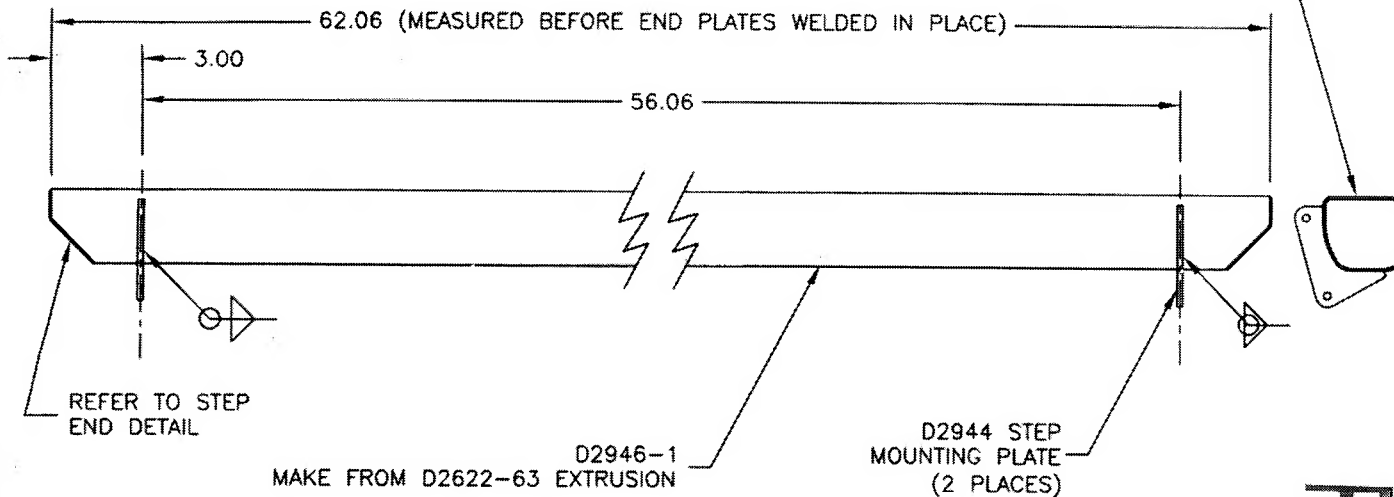
NOTE: ALL WELDS SHALL BE  
100% VISUALLY  
INSPECTED BY A UNCONTROLLED COP  
QUALIFIED INSPECTOR SUBJECT TO AMENDMENT  
PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING

WITHOUT NOTICE  
WORK ORDER  
NO. 83649 MJS

12/04/23



APPLY BLACK ANTI-SKID  
ON TOP SURFACE TO  
BOTTOM OF TOP RADIUS



## **D2946-041 STEP ASSEMBLY**

### **D2946 STEP ASSEMBLY**

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CP		PH			
CHECKED		APPROVED		DRAWING NO.	REV. B
				D2946	SHEET 1 OF 1
DATE				TITLE	SCALE
05.11.14				STEP ASSEMBLY	1:6
A		99.12.13		NEW ISSUE	
B		05.11.14		UPDATE FINISHING NOTE	

RELEASED  
05.11.28

**DART**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G

Date: 08.10.06

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

## ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT







The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 09.06.24  
CERT. NO.: SH92-6  
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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